

Work Order ID 58519

May 10, 2010 9:06:21 AM

Page 1

Item ID: D205-596-101

Accept

Setup Start

Revision ID:

Item Name: Crosstube Fwd Extended

Stop

Start Date: 5/10/10 Start Qty: 1.00

Required Date: 5/10/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D205-596

Rev B

100

0.00

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-594 bluefile & type labels per PPP D205-596-101 CHG002

200

0.00

Crosstubes

Crosstubes

Memo

0.00

Crosstubes

D205-596-101 B40782 pulled for trial insatallation
: touch up paint as necessary

210

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

DART Dart Aerospace Ltd. 270 ABERDEEN ST HAWKESBURY ON CANADA K6A 1K7				TO APPROVAL: 4-6-08 TEL: 1-613-532-5200	
P/N	D205-596-101	Q/C	CHG002		
DESC.	Crosstube Fwd Extended	S/C	SH03-6		
LOT	B40782	S/C	SR01742NY		
MOHL	205/212	S/C			
MADE IN CANADA				027234	

D M 10.05.10 ①

1005-11

Work Order ID 58519

May 10, 2010 9:06:22 AM

Page 2

Item ID: D205-596-101

Revision ID:

Item Name: Crosstube Fwd Extended

Start Date: 5/10/10 Start Qty: 1.00

Required Date: 5/10/10 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



Packaging

Packaging

0.00

Memo

0.00

Packaging

re-package per PPP, using new B/N

100511

1

230



QC

Quality Control

QC21 - Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/12
MF
10-5-11

Picklist Print

May 10, 2010 9:06:20 AM

Page 1

Work Order ID: 58519



Parent Item: D205-596-101



Parent Item Name: Crosstube Fwd Extended

Start Date: 5/10/10

Required Date: 5/10/10

Comments: IPP Rev G Removed Bending 05-10-25 JLM
IPP Rev:H ECN 1075 08-01-10 DD
IPP Rev I 08.04.28 Added bending & mat'l EC verified by: DD
IPP Rev:J 08-08-19 remove QC4 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D205-596-101

Manufactured No

Each 7.0000














Crosstube Fwd Extended

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG113	7	
37906	1	
39551	1	
40782 ✓	1	
41262	1	
41263	1	
44268	1	
44269	1	

ms 0-5-11

Date: Tuesday, 29/07/2008 4:55:37 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD X-TUBE EXTENDED HEIGHT GEAR (-011)
Job Number : 40782	
Estimate Number : 10007	
P.O. Number :	Part Number : D205596101
This Issue : 29/07/2008 S.O. No. :	Drawing Number : D205-596-101
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : CROSSTUBES	Drawing Revision : B
Previous Run : 39552	Material :
Written By :	Due Date : 15/08/2008 Qty: 1 Um: Each
Checked & Approved By : <u>08.7.29 JLD</u>	
Comment : Est Rev G Removed Bending 05-10-25 JLM Est Rev:H ECN 1075 08-01-10 DD Est Rev F 08.04.28 Added bending & mat'l EC verified by: DD	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
Description :	
1.0 DC	DOCUMENT CONTROL
	
	
Comment: DOCUMENT CONTROL Photocopy D205-594 bluefile & type labels per PPP D205-596-101 CHG002 <u>So 8/08/12</u>	
2.0 D6005180	Crosstube Material
	
	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Crosstube Material Batch: <u>B38345</u> <u>DP 8-8-12</u>	
3.0 BENDING	BENDING MACHINE - SKIDTUBES
	
	
Comment: BENDING MACHINE Bend as per Dwg D2889 using CNC bender program <u>DP 8-8-12</u>	
4.0 CROSSTUBES	CROSSTUBES RESOURCE 1
	
	
Comment: LANDING GEAR RESOURCE 1 Mark 31.53" for cutting from tangential line in the straight section from D2889 as per Dwg wall template ***Identify off-cuts with batch number & part number and bring them to cnc lathe*** <u>DP 8-8-12</u>	
5.0 QC15	DIMENSIONAL CHECK OF X-TUBES
	
	
Comment: DIMENSIONAL CHECK OF X-TUBES <u>08-08-12</u>	

Date: Tuesday, 29/07/2008 4:55:37 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001, Dart Helicopters Services

Drawing Name: FWD X-TUBE EXTENDED HEIGHT GEAR (-011)

Job Number: 40782

Part Number: D205596101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

CROSTUBES

CROSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-101

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and end of tube.

Batch # on one

7 8.8.13

7.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

7 08.08.14

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat per QSI 005 4.1

SL 8.8.13

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7 08.08.14

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside and outside with Immron per QSI 005 4.2

RT 08.08.14

11.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

ml 08.08.18 (1)

12.0

D3595063450

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

RUBBER CUSHION

batch 385001

ml 08.08.18

13.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Clamp(per MIL-DTL-8783C)

batch 108111

ml 08.08.18

Date: Tuesday, 29/07/2008 4:55:37 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXTENDED HEIGHT GEAR (-011)

Job Number: 40782

Part Number: D205596101

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D28931

2.75 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Support

Pick:

Qty Part number Description Batch

2 D2893-1

Support

38124

ml 08 08 18

15.0

CROSTUBES

CROSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

ml

08 08 18 ①

2- Apply magnobond 6398 as per dwg D205-596-101.

Magnobond 6398 Batch: 107621

EXP: 08/2009 time: 10:15 am

3 - install supports and clamps as per Dwg D205-596-101. Torque clamps to 80-100 in lb. as per dwg

ml

08 08 19 ①

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/12 @

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/08/12 @

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-101

Location:

8/8/19

(X)
90

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/2008

Job Completion

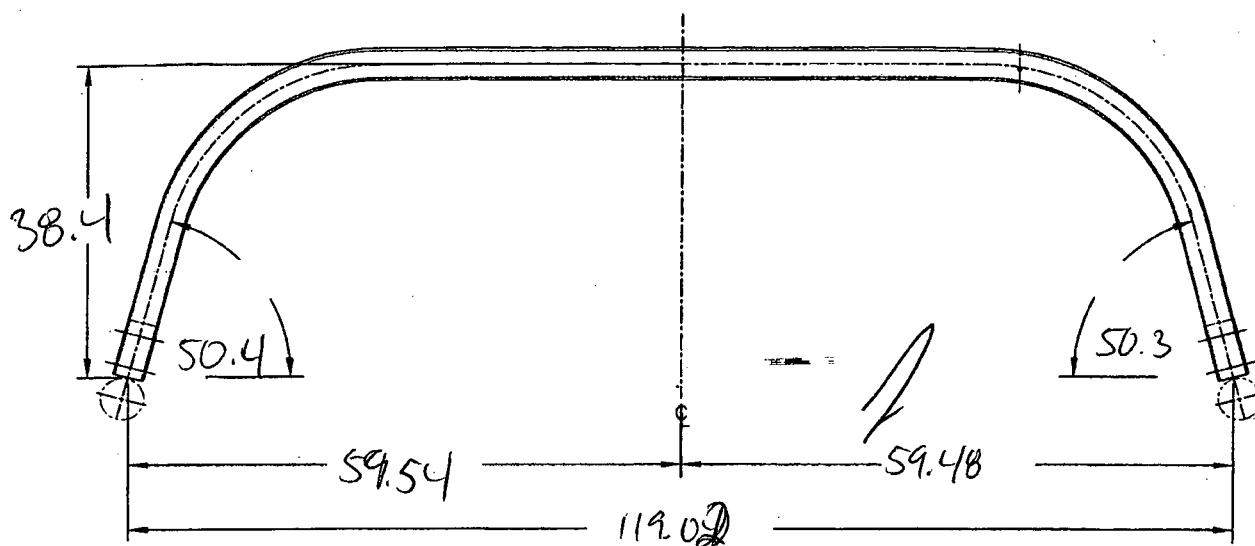


mf 08-08-19

B40782

DART AEROSPACE LTD		Work Order:	40782
Description: Crosstube High-High Fwd		Part Number:	D205-596-101
Inspection Dwg: D205-596-101 Rev: B			Page 1 of 1

Required Dimension	Min	Max
Height	38.2	38.4
1/2 Span	59.5	59.7
Angle	49	52
Total Span	119.0	119.4



Comments

QC15 Inspection	
Date	08-08-12

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	

PARTS LIST:

Qty	Part Number	Description
X	D205-596-101	CROSSTUBE ASSEMBLY, HI-HI FWD
1	D6005-180	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

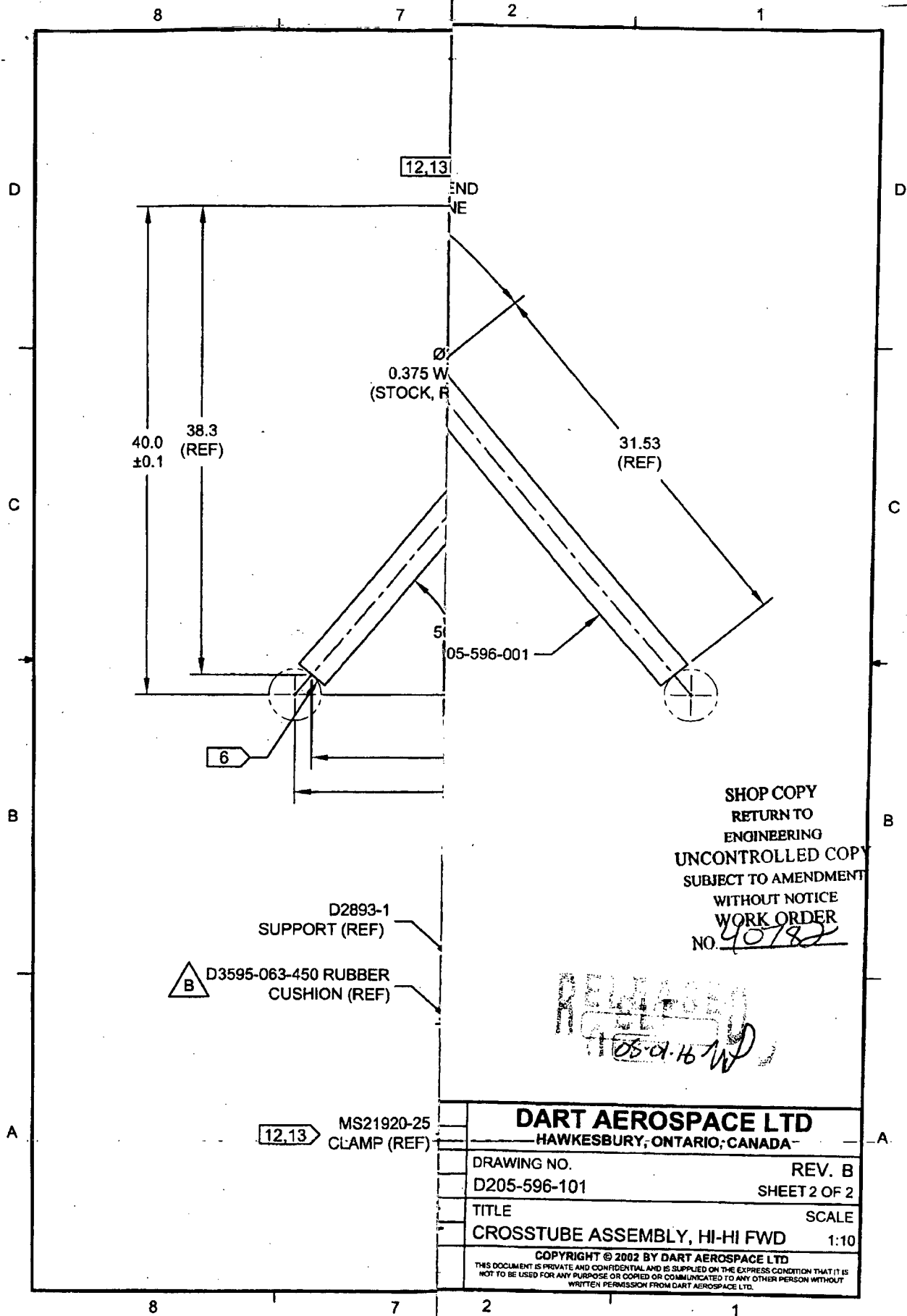
- 1) MATERIAL: MANUFACTURE FROM D6005-180
FINISHED LENGTH = 149.60 ± 0.02
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH
VIBRATING STYLUS
- 7) WEIGHT: 44 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT
WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION
AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE D2893-1
SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE
CROSSTUBE SUPPORT.
NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-25 CLAMPS WITH LONGER (MS21920-26) OR
SHORTER (MS21920-24) CLAMPS TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A
MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB

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RELEASED
(60-01-161W)

B	SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-851 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-450 CUSHION; MS21920-25 WAS MS21920-24	MB	07.12.03
A	NEW ISSUE	DS	02.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD.	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D205-596-101	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSEMBLY, HI-HI FWD	NTS
DATE	07.12.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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WORK ORDER
NO. 40782

RELEASED
11-05-01-16 W

12,13 MS21920-25
CLAMP (REF)

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D205-596-101 SHEET 2 OF 2

TITLE SCALE
CROSSTUBE ASSEMBLY, HI-HI FWD 1:10

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Wednesday, 02/04/2008 3:39:41 PM

Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: X-TUBE MATERIAL
Job Number	: 38345		
Estimate Number	: 12127		
P.O. Number	:	Part Number	: D6005180
This Issue	: 02/04/2008 S.O. No. :	Drawing Number	: D6005 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : LANDING GEAR	Drawing Revision	: A
Previous Run	: 34687	Material	:
Written By	:	Due Date	: 26/09/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>JD 08.04.03</u>		
Comment	: Est Rev:C 04.06.15 Added tolerance to Step 2 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 6063

C 208/04/04 (20)

- a) Extrude as per Dwg D6005 length = 180" (Ref. D6005-180)
 b) Material: 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11)) Seamless aluminum tube
 c) Minimum ultimate tensile strength = 77ksi
 d) Minimum tensile yield strength = 66ksi
 e) Material certification required

2.0	D6005180P	Crosstube material
-----	-----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
 Crosstube extrusion

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

B 08/08/11
 Rea 20x 08/07/11

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK
 Ensure Material certification comply to Dwg D6005

C 08/08/11 (20)

Wednesday, 02/04/2008 3:39:41 PM

Julie Lecocq,

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE MATERIAL

Job Number: 38345

Part Number: D6005180

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 8-8-12

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP

8-8-12

20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L.G

M 8-8-12

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/14

20

Job Completion



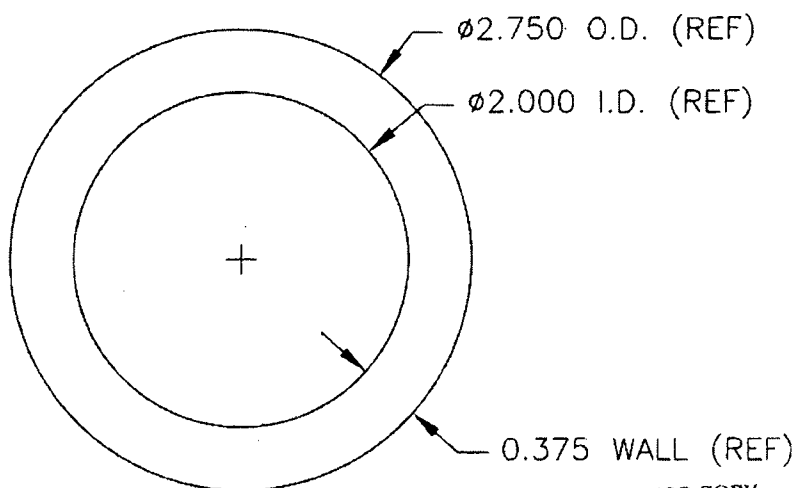
mf 08-08-13



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D6005	REV. A SHEET 1 OF 1
DATE 00.11.17		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	00.11.17	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
00.11.24 *A*



NOTES

- 1) D6005-XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 128" LONG TUBE: D6005-128

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WORK ORDER
NO. 38345

- 2) MATERIAL: 2.750 OD x 0.375 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.006 MEAN (± 0.012 INCLUDING OVALITY)
WALL: ± 0.015 MEAN (± 0.038 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.125/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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ALUnna

Abnahmeprüfzeugnis 3.1 - EN 10204:2004

Inspection Certificate 3.1 - EN 10204:2004 / Certificat de Reception 3.1- EN 10204:2004

Kunde: Dart Aerospace Ltd.

Client:

1270 Aberdeen Street
K6A1K7 Hawkesbury, ON Canada

Zeugnisnummer: 996/08

Cert No. / No. du certificat:

Bestellnummer: P000006063

Order No. / No. de commande

Auftrag: 29104/1

Our Reference/Notre Référence:

Produkt: Rohre nahtlos gepresst

Product / Produit: Tubes seamless extruded

Spezifikation: -; AMS - QQ - A - 200/11E; -; -; Spezifikation Dart Aerospace D 6005

Specification:

Werkstoff: 7075

Alloy/Alliage:

Zustand: T 6511

Temper/État

Abmessung: 2,750 INCH x 2,000 INCH x 0,375 INCH x 180,000 INCH

Size / Dimension: D6005-180 2.750 x 0.375 x 180

Kennzeichnung: ALUnna - Cert No. 996/08 - 7075 - T 6511 - Cast No. 81741 - AMS - QQA 200/11 - 2.750" OD X 0.375" Wall - Heat

Marking/Marquage: Lot No. 1798 - ALUnna Order Conf. No. 29104/1-1 PO. 00006063

Lieferung

Delivered Material / Matériel délivré:

Stück

kg

19

440,00

1. Chemische Analyse

Chemical Analysis / analyse chimique

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Zr	Bi	Sn	Ni
Charge/ min.			1,2		2,1	0,18	5,1						
Cast No. max.	0,40	0,50	2,0	0,30	2,9	0,28	6,1	0,20					
81741	0,07	0,14	1,46	0,04	2,47	0,19	5,83	0,04	0,01	0,03	0,01	0,01	0,01

2. Mechanische Eigenschaften

Mechanical Properties / Valeurs Mécaniques

Anforderungen Requirements	tensile (Rm) ksi	yield (Rp0,2) ksi	elongation 2" %	elongation A %	Hardness HB	Heat Lot No.
min.	77,0	66,0				
max.						
1	88,160	81,925	8,0			1798 - 19 pcs.
2	89,030	82,940	8,0			

Ergebnis der Prüfungen:

Es wird bestätigt, daß die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellannahme entspricht

Test results:

We confirm that the delivery has been tested and applies to the agreements made on receipt of the order

Resultats:

Nous confirmons que la livraison a été contrôlée et correspond avec les conventions faites à la réception de la commande

15.07.2008 / azbqs



Certified acc. DIN EN ISO 9001:2000 and DIN EN 9100:2003

valid until 2010-11-11

CEP No. 001050 OM: 001050 ASU



ALUnna



Aluminiumwerk Unna AG · Uelzener Weg 36 · D-59425 Unna

Aluminiumwerk Unna AG

Uelzener Weg 36 · D-59425 Unna
Postfach 11 46 · D-59401

fon +49 (0) 23 03-206 -0
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Petra@aluminiumwerk.com
www.aluminiumwerk.com

DART AEROSPACE LTD.
1270 Aberdeen Street
CDN K6A 1K7 HAWKESBURY
ON
Canada

page: 1
date: 7.17.2008
customer: 40980

invoice

42659

your PO dated: 4.03.2008
your PO No.: PO00006063
confirmation No.: 29104
Delivery note: 0042490 17.07.2008

contact: Petra Eisenblätter
Tel.: +(303) 755 5672
Fax: +(303) 755 5936

representative: CLAUS J. BETTER
Tax code 316/5702/0535

We supply acc. to our delivery terms and conditions:

item	quantity	unit	price	USD	unit	value	USD
001	19,000	PC	610,00	PC		11.590,00	

AWU article: 19797 / Tariff no. 76082081
Customer article: D6005-180 2.750 X 0.375 X 180
product: TUBES / seamless extruded / EN AW-7075 / round
condition: T 6511 / AMS-QQ-A-200/11

outer diameter:	69,850 mm	Tol.	+0,300	-0,300
tol. for mean OD			+0,150	-0,150
inner diameter:	50,790 mm			
wall thickness:	9,530 mm	Tol.	+0,970	-0,970
fixed length	4572,000 mm	Tol.	+3,175	

inspection cert. acc. to EN10204/3.1 / RM 531 / Rp0,2: 455
straightness 0,25 mm / 304,8 mm / RMS outer 25
tol. on quantity +10 % -10 %
2.750" OD 0.375" Wall, 180" lengths
Part Number D6005-180 crosstube
Surface Finish max. RMS 25

carried forward: 11.590,00

Commerzbank AG, Unna
Konto-Nr. 102 56 00 · BLZ 443 400 37
S.W.I.F.T. - Code: COBADE 33 443
IBAN : DE 90 4434 0037 01025600 00

Sitz der Gesellschaft: Unna
Amtsgericht Hamm HRB 3045
Vorstand: Volker Findelsen (Vors.)
Thomas Wiese
Vorsitzende des Aufsichtsrats: Irene Wiese



invoice

42659

page: 2
date: 7.17.2008
customer 40980

Tolerances per ASTM B210 / your drawing D6005
Tubes protected with corrosion protective oil
Tubes line marked

Packing: seaworthy wooden cases

terms of delivery: DDP (Delivered, Duty, Paid)

Terms of payment: 30 days after date of delivery

delivery address:
DART AEROSPACE LTD.
1270 Aberdeen Street
CDN Hawkesbury, ONT, K6A1K7
Kanada

goods value: 11.590,00
total: 11.590,00

weight: gross 580,00 net 440,00
export exempt from tax - Country of origin: Germany

IMPORTER OF RECORD:
ALUMINIUMWERK UNNA-USA, INC.